

Work Order ID 85143

85143

Page 1

June-04-12 1:27:15 PM

Item ID: D350-636-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH

Stop ***NS2***

Start Date: 04/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750	F
D3492	C

MLJ 12/07/11

100
100 DOCUMENT CONTROL

0.00

DC Memo 0.00

Document Control Photocopy blue file and type labels per PPP D350-636-012 CHG 006

12/07/12
JB

B85143 RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop ***NR2***Sequence ID/
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Tool #

Plan
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QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr.4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade
fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail L to 0.500" (8 holes per side)9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

12/06/25

B

12/06/28

12/06/25

B 12/06/28

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Date:

SPC (Y/N):

Date:

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Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch: M122130BE 12/06/25

12-Grind welds flush as per Dwg D2750

BE 12/06/26

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

8.2/06/28

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

8.17/06/28

Quality Control

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Run Start ***NR1***
Stop ***NR2***

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140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

1 RH ~~Q~~ ~~Q~~ 12/07/03.

① SAT 1d-07-03

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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SPC (Y/N):

Date:

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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 121409exp. date: 13-4-12

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M122130

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

SAD 12-07-03

- DC 12/07/03

BE 12/07/04

BE 12/07/06

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Date:

Stop ***NR2***Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

dwg D2750

12-Deburr holes

BE 12/07/06

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

Scablos

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

Scablos

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	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 7/16 12-79

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

200

Powdercoat

Powder Coating

Memo

0.00

START TIME: 9:30

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:00

1X Ø M-L 12/07/09

210 QC3- Inspect Part Finish 0.00

210

QC

Quality Control

Memo

0.00

Inspect for foreign object per QSI 024

1B71 d 12/07/10

M121841

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Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00

230

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ 1-Install inserts as per dwg D2750

✓ 2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"

- batch: N 1A

4-Install blade fitting D3488-042. wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: AA121130EXP DATE: 12/10/3

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: AA110348

6-Coat all exposed fasteners with "LPS Procyon"

batch: M110396IRH ϕ M 120710

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240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/2/11					
250 *250* Packaging Packaging	Pick Kit Memo	0.00 0.00							
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		AS 12/9/12					

6/12/11 ①



Dart Aerospace Ltd

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Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

270

Packaging

Packaging

0.00

Memo

0.00

Packaging

Package as per PPP D350-636-012

280

280

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MLJ 12/07/13

MLJ 12/07/13

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Picklist Print

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D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	29.0000	1	1			

D2600-3-BENT

Extrusion Bent

**

BA 12/06/25

Location	Loc Qty	Loc Code
LG	29	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
83442	13	

D2744

Manufactured No

110

Each

35.0000

1

1

D2744

Cap

**

BA 12/06/25

Location	Loc Qty	Loc Code
LG002	35	
62715	1	
78900	3	
83412	31	

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85143

D350-636-012

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

13.0000

1

1

D2739

350 I Beam

**

DL 12/07/03
①

Location	Loc Qty	Loc Code
B85486		
LG	13	
72155	1	
81508	1	
83447	4	
83448	5	
83548	2	

D2743

Manufactured No

160

Each

296.0000

8

8

D2743

Crossbolt Spacer

**

BE 12/07/04

Location	Loc Qty	Loc Code
LG	222	
81965	55	
83262	167	
LG001	74	
67766	4	
68251	3	
73403	64	
74445	1	
79517	2	

D3490-3

Manufactured No

160

Each

46.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE 12/07/04

Location	Loc Qty	Loc Code
LG001	46	
83313	46	

4

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Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

45.0000

4

4

D3490-1

Cross Bolt Spacer

**

BB12/07/07

Location

Loc Qty

Loc Code

LG

2

81976

2

LG001

43

62450

2

74875

4

77042

3

83269

34

4

D3631-1

Manufactured No

230

Each

347.0000

8

8

D3631-1

Washer

**

yl 12/07/10

Location

Loc Qty

Loc Code

FG

332

81874

2

83588

330

x8

ST072

15

68062

2

75548

13

D3791-1

Manufactured No

230

Each

17.0000

1

1

D3791-1

Wearplate

**

yl 12/07/10

Location

Loc Qty

Loc Code

FP002

17

62239

2

83392

15

x1

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Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

28.0000

1

1

D3793-3

Wearshoe

**

28 12/07/10

Location

Loc Qty

Loc Code

FP001

28

83394

16

83901

12

MS21043-6

Purchased No

230

Each

618.0000

4

4

MS21043-6

NUT

**

28 12/07/10

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

598

117887

2

118384

96

120308

500

D3794-1

Manufactured No

230

Each

26.0000

1

1

D3794-1

Gasket

**

28 12/07/10

Location

Loc Qty

Loc Code

FP

6

82167

6

FP002

20

83395

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 85143

85143

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

188.0000

8

8

NAS1611-010

O-RING

**

22 12/07/10

Location

Loc Qty

Loc Code

FP001

188

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121415

4

121584

59

121723

50

18

D2741

Manufactured

No

250

Each

20.0000

1

1

D2741

Blade, 350 Skidtube

**

83135 JB 12/07/11

Location

Loc Qty

Loc Code

ST

-10

ST466

30

71856

1

79516

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 85143

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

85143

D350-636-012

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

146.0000

4

4

*NAS1515H3I * ?

WASHER

**

HL 12/07/10

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

106

118686

3

119438

1

120360

11

121243

2

121556

89

x 4

NAS1611-013

Purchased

No

230

Each

361.0000

8

8

NAS1611-013

O-RING

**

HL 12/07/10

Location

Loc Qty

Loc Code

FP001

361

116582

5

117291

2

117887

53

119623

36

121584

15

121825

200

121826

50

x 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85143

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

85143

D350-636-012

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

451.0000

4

4

AN3C6A

BOLT

**

YH 12/07/10

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

450

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

158

121682

200

XI

NAS1149C0832R

Purchased

No

230

Each

257.0000

1

1

NAS1149C0832R

WASHER

**

YH 12/07/10

Location

Loc Qty

Loc Code

ST297

257

114915

257

XI

D3536-25

Manufactured

No

230

Each

28.0000

1

1

D3536-25

Gasket

**

YH 12/07/10

Location

Loc Qty

Loc Code

FP

28

83391

12

83900

16

XI

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85143

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

85143

D350-636-012

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

23.0000

1

1

D3794-3

Gasket

**

22 12/07/10

Location

Loc Qty

Loc Code

FP

21

83396

21

FP002

2

74530

2

AN3C5A

Purchased

No

230

Each

1,302.000

34

34

AN3C5A

Bolt

**

22 12/07/10

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1295

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255

500

121444

182

121708

500

x 34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85143

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

85143

D350-636-012

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

83.0000

3

3

D3537-1

Wearpad

**

ML 12/07/10

Location

Loc Qty

Loc Code

FG

10

B83256

x3

79833

10

FP002

73

69817

5

81360

14

81362

19

83254

1

83255

3

84091

31

D3535-25

Manufactured No

230

Each

34.0000

1

1

D3535-25

Wearshoe

**

ML 12/07/10

Location

Loc Qty

Loc Code

FP001

34

62233

1

81357

1

82156

2

83387

17

83899

13

D3492-3

Manufactured No

230

Each

167.0000

8

8

D3492-3

Plug

**

ML 12/07/10

Location

Loc Qty

Loc Code

FP-A

167

81967

5

83099

40

83529

122

x1

x7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85143

85143

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

230 Each 0.0000 38 38

*AN960C10I * *

washer

1122063

**

1x38 M n/02/10

D3488-042

Manufactured No

230 Each 9.0000 1 1

D3488-042

Blade Fitting Assembly, RH

**

M n/02/10

Location

Loc Qty

Loc Code

FP002

9

B 83417

x1

62003

1

77015

1

82258

7

ALS4-1032-225

Purchased No

230 Each 781.0000 38 38

AI S4-1032-225

Insert

**

M n/02/10

Location

Loc Qty

Loc Code

ST281

758

108696

146

110768

62

118386

55

118966

68

121269

427

1122290

x38

ST282

23

120410

10

120451

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85143

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

85143

D350-636-012

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

257.0000

8

8

D3492-1

Plug

**

JD

12/03/10

Location

Loc Qty

Loc Code

FP002

242

69531

8

74444

2

76235

4

83259

228

FP-A

15

83098

15

x 8

D3793-1

Manufactured No

230

Each

28.0000

1

1

D3793-1

Wearshoe

**

JD

12/07/10

Location

Loc Qty

Loc Code

FP001

28

82171

2

83393

13

83903

13

x 1

AN8C35A

Purchased No

230

Each

68.0000

1

1

AN8C35A

BOLT

**

JD

12/02/10

Location

Loc Qty

Loc Code

FP002

67

115960

1

118286

16

121275

50

ST346

1

114442

0

115188

0

115960

1

~~MITCHELL~~

v 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 85143

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

85143

D350-636-012

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

81.0000

1

1

MS21083C8

NUT

**

u 12/07/10

Location

Loc Qty

Loc Code

304

75

121185

29

121349

46

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

1

121524

1

D2745

Manufactured

No

230

Each

122.0000

8

8

D2745

Bushing

**

u 12/07/10

Location

Loc Qty

Loc Code

FP

6

79518

6

FP001

116

69529

1

76142

1

83260

114

X 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85143

85143

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

86.0000

4

4

AN6C44A

**

BOLT

24 11/07/11

Location

Loc Qty

Loc Code

FG

2

11121440

24

103964

2

ST343

84

121013

11

121167

13

121440

50

121689

10

D3532-1

Manufactured

No

250

Each

7.0000

2

2

D3532-1

**

Spacer

83319 23 12/07/11

Location

Loc Qty

Loc Code

ST053

7

82041

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85143

85143

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

81.0000

2

2

**

MS21083C8

NUT

Location

Loc Qty

Loc Code

304

75

121185

29

121349

46

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

1

121524

1

121349

NAS1149D0863J

Purchased

No

250

Each

251.0000

2

2

**

NAS1149D0863.I

WASHER

Location

Loc Qty

Loc Code

ST298

251

118078

34

119307

17

120308

100

121556

100

120308

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85143

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

85143

D350-636-012

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

127.0000

2

2

**

D3493-1

Washer

Location

Loc Qty

Loc Code

ST050

127

77573

1

82023

26

83097

100

Purchased

No

250

Each

57.0000

2

2

**

AN8C21A

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

57

118758

3

121167

4

121275

50

83097

121275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/2-3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 85143 MCT
12/06/04

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 91339157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.

D2750

REV. F

SHEET 1 OF 11

TITLE

350 SKIDTUBE ASSEMBLY

SCALE

NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

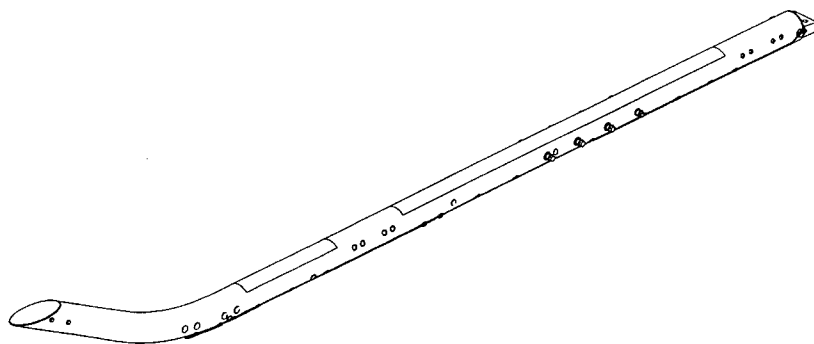
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

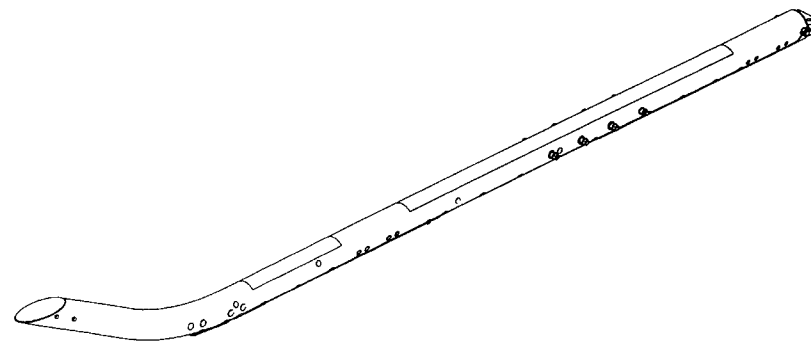
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8517/3



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
18 APR 1974

DESIGN	PC	DART AEROSPACE USA, INC.	
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CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 2 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

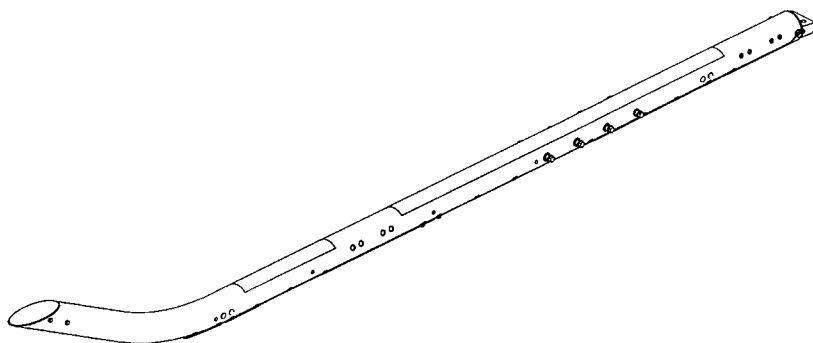
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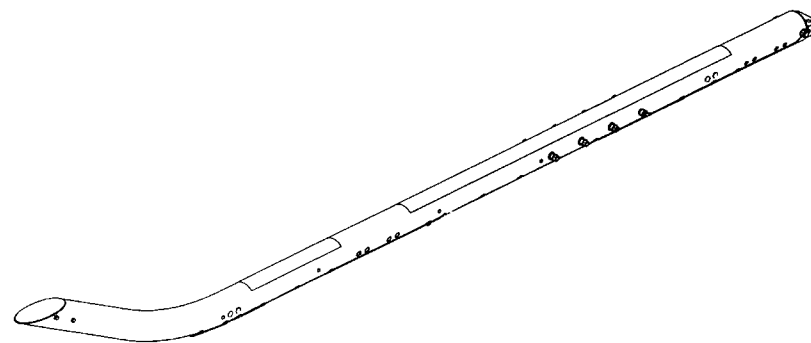
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85143



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/14

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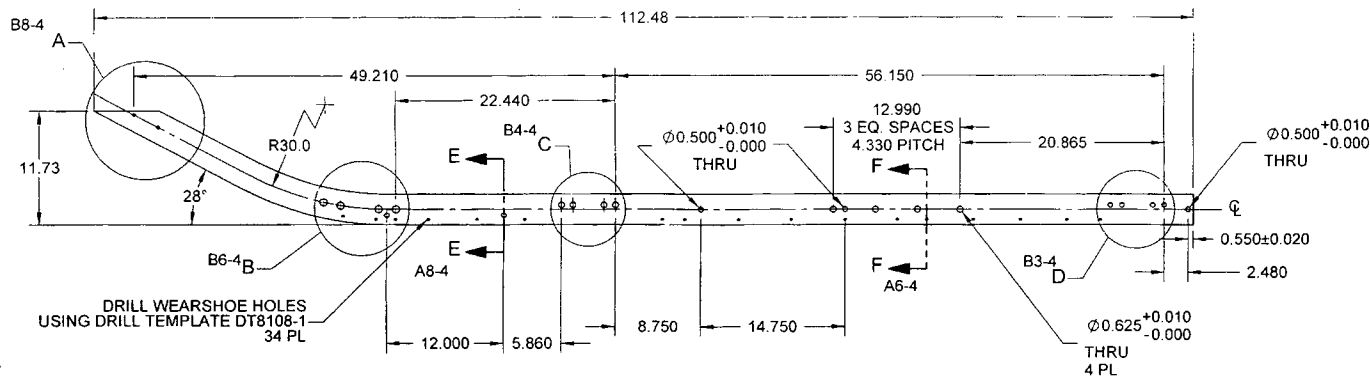
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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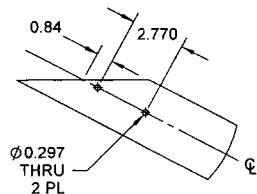
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

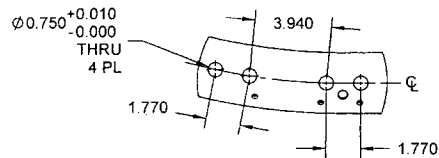
NOTE: Date & initial all entries



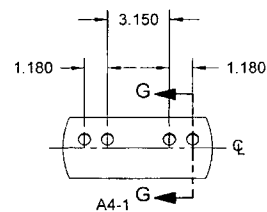
D2750-1 LH SKIDTUBE



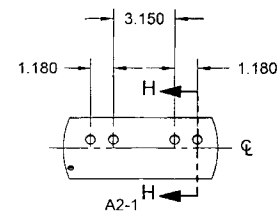
DETAIL A
SCALE 2X



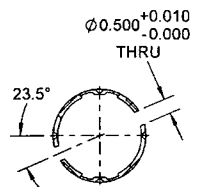
DETAIL B
SCALE 2X



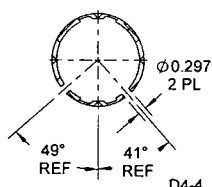
DETAIL C
SCALE 2X



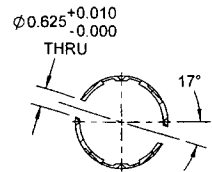
DETAIL D
SCALE 2X



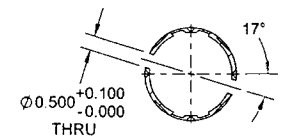
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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DATE		08.07.16	

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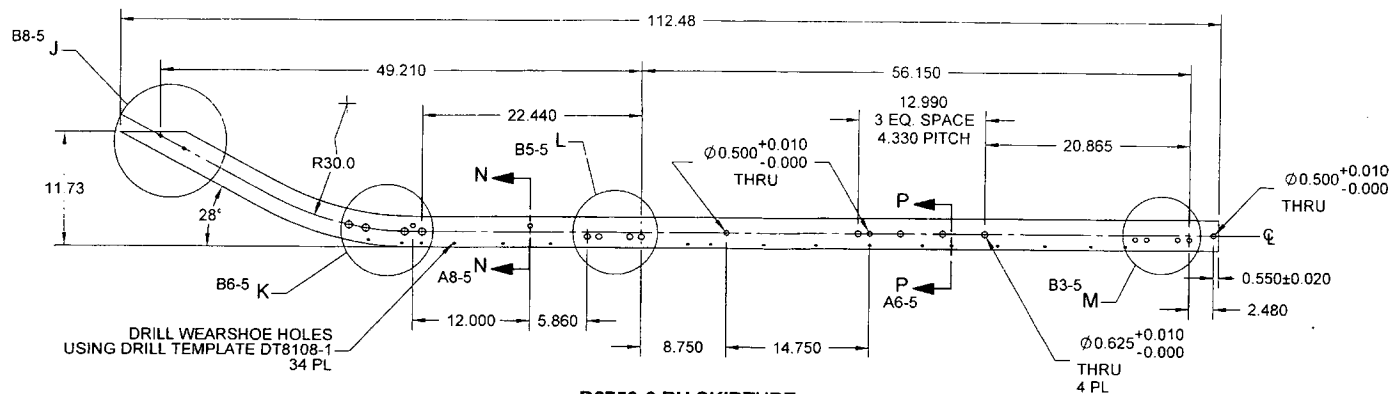
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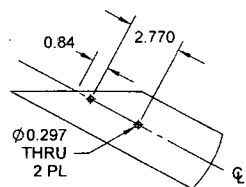
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

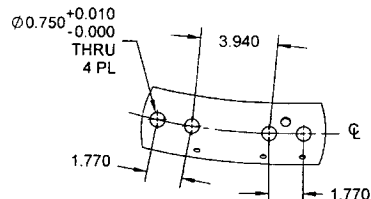
85143



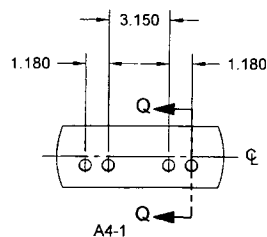
D2750-2 RH SKIDTUBE



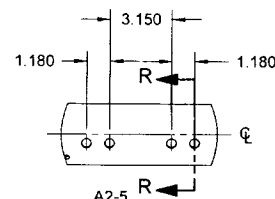
DETAIL J
SCALE 2X



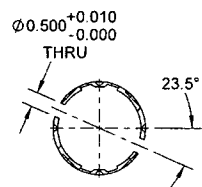
DETAIL K
SCALE 2X



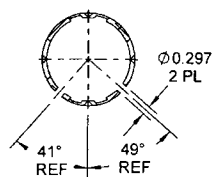
DETAIL L
SCALE 2X



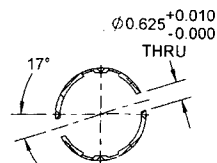
DETAIL M
SCALE 2X



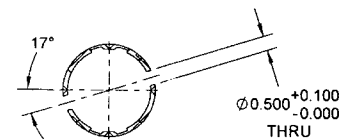
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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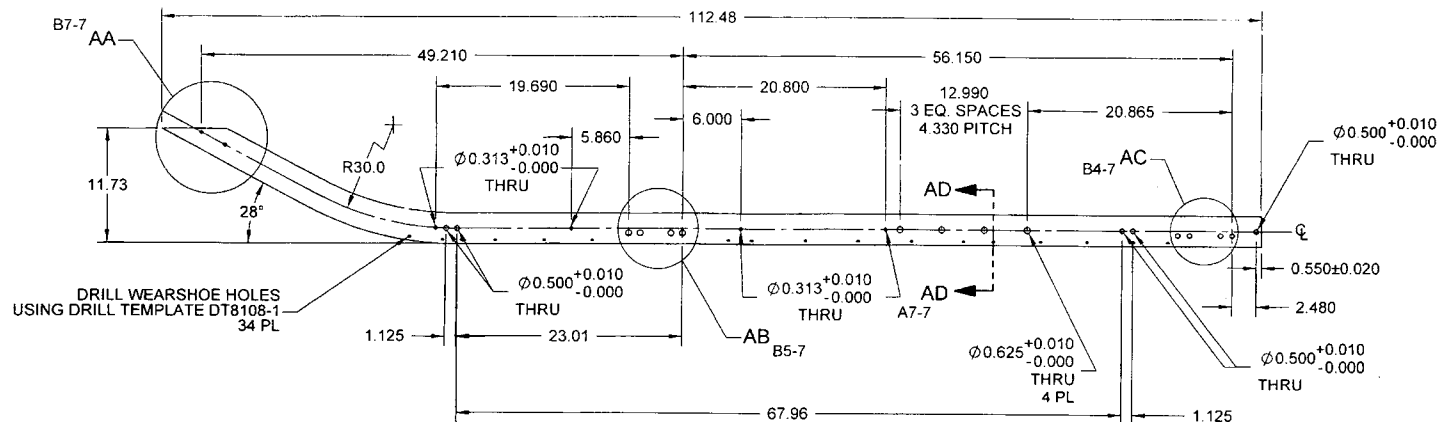
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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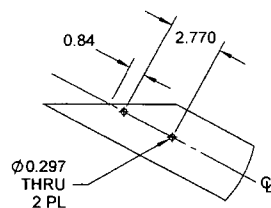
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

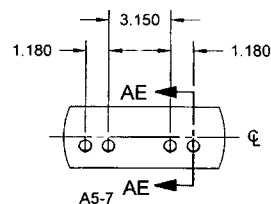
NOTE: Date & initial all entries



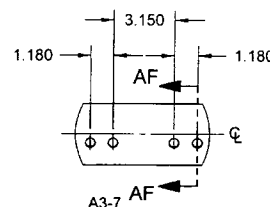
D2750-4 RH SKIDTUBE



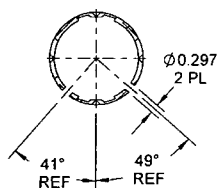
DETAIL AA
SCALE 2X
D7-7



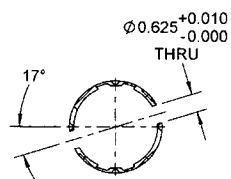
DETAIL AB
SCALE 2X
C4-7
A5-7



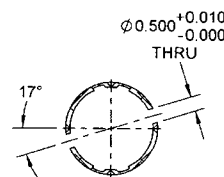
DETAIL AC
SCALE 2X
D3-7
A3-7



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7



SECTION AF-AF
SCALE 3X, 4 PL
B4-7

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06-02-16

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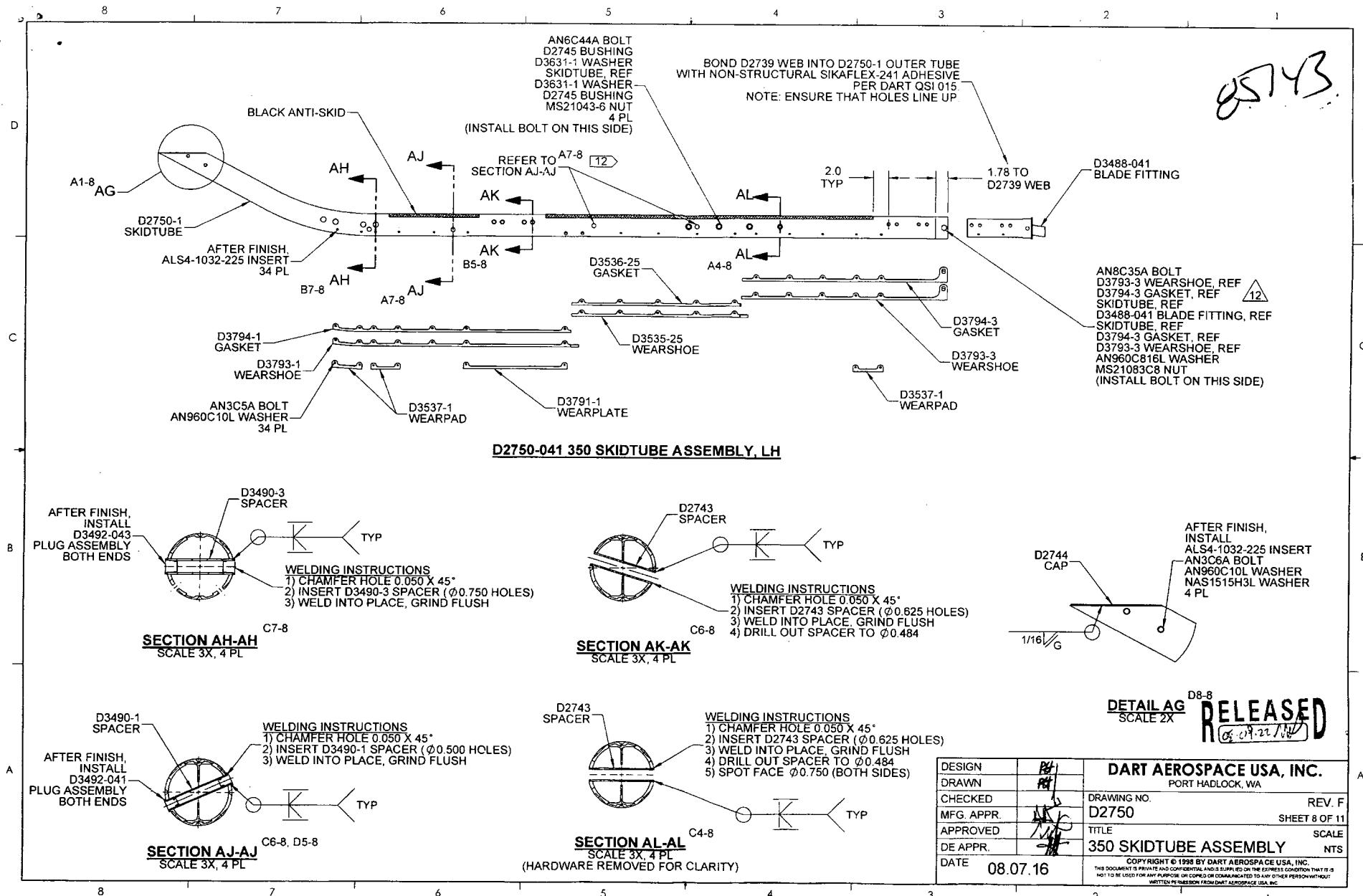
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

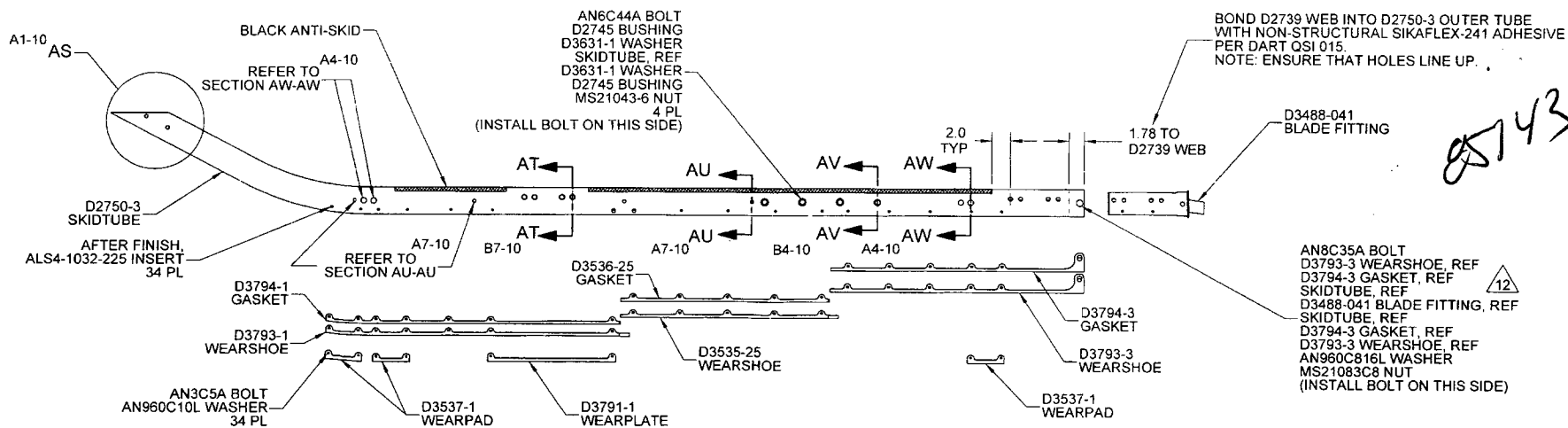
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

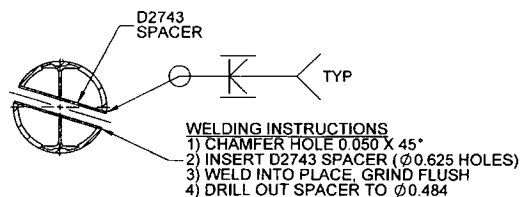
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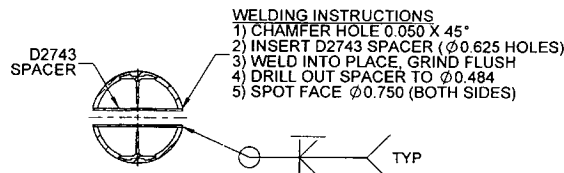
NOTE: Date & initial all entries



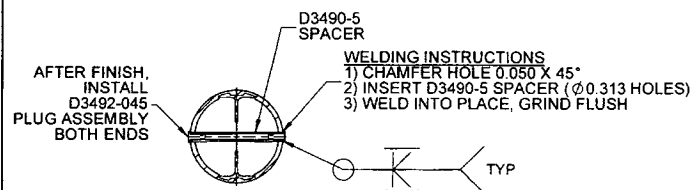
D2750-043 350 SKIDTUBE ASSEMBLY, LH



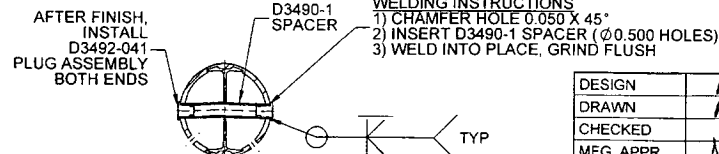
SECTION AT-AT
SCALE 3X, 4 PL



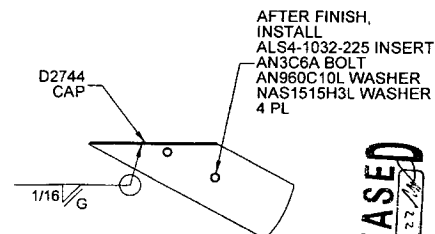
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



DETAIL AS
SCALE 2X

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DRAWN	RA	PORT HADLOCK, WA	
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2018-09-27

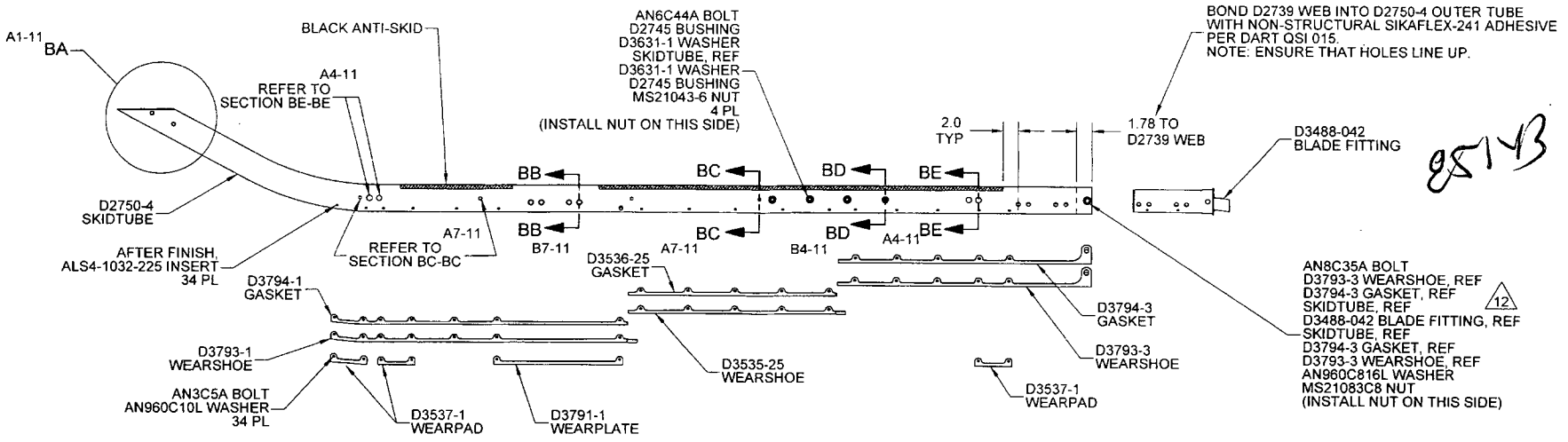
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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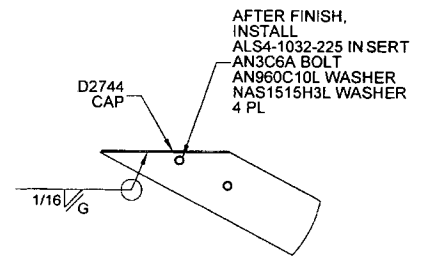
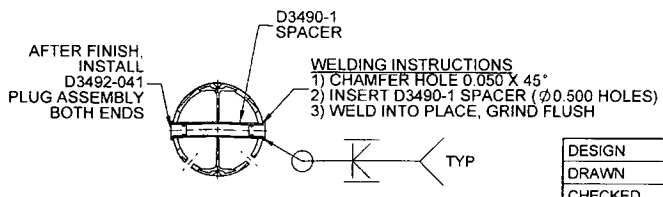
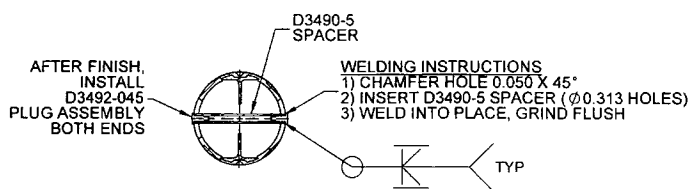
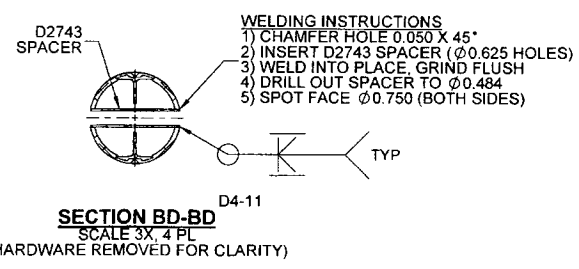
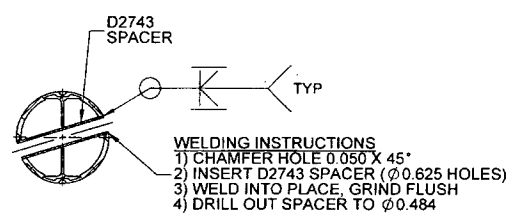
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-044 350 SKIDTUBE ASSEMBLY, RH



RELEASED
06-07-12 / M/W

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CHECKED	HA	DRAWING NO.	REV. F
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 294

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 83800
Part number: A350-636-012
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Anna Date of Test Coupon 12.05.09

Welder Barclay Elliott Date of Test Coupon 12.05.09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld